

152630

Page 1

N900040100

Setup Start *NS1*

Stop ***NS2***

Start Date: 11/1/2016 **Start Qty:** 1.00 ***1***

Cust Item ID:

Required Date: 11/8/2016 **Req'd Qty:** 1.00 ***1***

Customer:

Approvals:

Process Plan:	DAS 21 9-89	Date:	NOV 01 2016	Cooling:		Date:	
QC:		Date:		SPC (Y/N):		Date:	

Run	Start	*NR1*
	Stop	*NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr	DAS 21 9-89	NOV 01 2016
		DAS	

100

Memo

Doc.Control -USB or Paperwork

Photocopy bluefile & type labels per PPP D206-781-371KIV
CHG001

110

Packaging

Packaging

Pick Kit

0.00

Memo

0.00

120

QC

Quality Control

QC4- 100% Inspect kits for completeness

0.00

Memo

0.01

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition			
				Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐	
OTHER :					

Work Order ID 152630***152630***

Page 2

Tuesday, November 01, 2016 12:39:35 PM

Item ID: D206-781-371KIV

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Hat Bin, Ivory

Start Date: 11/1/2016 Start Qty: 1.00

1

Cust Item ID:

Required Date: 11/8/2016 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start ***NR1***

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

Identify as per dwg & Stock Location: _____

0.00

130

Packaging

Memo

0.00

Packaging

Identify and pack for shipping as per PPP D206-781-371KIV
Location: FG1191
DAS
28
9-89
NOV 01 2016

140

QC21- Final Inspection - Work Order Release

0.00

140

QC

Memo

0.02

Quality Control

DAS
21
9-89
NOV 01 2016DAS
21
9-89
NOV 01 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition			
				Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : ☐					

Picklist Print

Tuesday, November 01, 2016 12:39:43 PM

Page 1

Work Order ID: 152630

152630

Parent Item: D206-781-371KIV

D206-781-371KIV

Parent Item Name: Hat Bin, Ivory

Start Date: 11/1/2016

Required Date: 11/8/2016

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP RevA: New issue DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
AN525-10R14 Screw		Purchased	No			110	Each	69.0000	4	4		NOV 01 2016	
AN525-10R14													
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST327		69							
				115371		69							
D3845-1KIV Hat Bin-Ivory		Manufactured	No			110	Each	0.0000	1	1		NOV 01 2016	
D3845-1KIV													
D3851-1KIV Doubler-Ivory		Manufactured	No			110	Each	9.0000	6	6		NOV 01 2016	
D3851-1KIV													
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST055		9							
				51798		9							

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :				MRB (QSI042) Approval 	
Description Work Order Deviation				Disposition					
								Completed By	
								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	

Root Cause				FAULT CATEGORY			
Environment ☐	☐	No Re-verification ☐		Pressure/Forced ☐	☐	Temperature/Cure ☐	☐
Design ☐	☐	Operator ☐		Bending ☐	☐	Set-up ☐	☐
Doc/Data ☐	☐	Offset/Setup ☐		Centre Not Concentric ☐	☐	BOM/Route ☐	☐
Equip/Tooling ☐	☐	Supplier ☐		Cracks ☐	☐	Broken/Damage/Defect ☐	☐
Handling/Pre ☐	☐	Training ☐		Crimp/Kink/Ripple/Wave ☐	☐	Inspection Incomplete/Unqualified ☐	☐
Material ☐	☐	Use for Testing ☐		Cuffs ☐	☐	Contamination ☐	☐
Internal Transport ☐	☐	Poor Information ☐		Crushing ☐	☐	Countersink ☐	☐
Tribal Knowledge ☐	☐	Rushing ☐		Heat Treat ☐	☐	Cut Too Short ☐	☐
LOA ☐	☐	Product Improvement ☐		Wave/Twist in Tube ☐	☐	Instructions Incomplete/Unclear ☐	☐
Substation ☐	☐	Process Improvement ☐		Marks/Chatter ☐	☐	Drill Holes ☐	☐
Past Expiry Date ☐	☐	Manufacturing Process ☐		OTHER : _____			
Misidentified ☐	☐	Past Due ☐					

5.0 PARTS LIST

REFERENCE ONLY5.1 BELL 206 L/L1

5.1.1 D206-781-311 UTILITY KIT

Qty -311	Part Number	Description
X	D206-781-311	UTILITY KIT
1	D206-781-341	CREW CABIN OVERHEAD KIT
1	D206-781-351	VERTICAL TUNNEL KIT
1	D206-781-361	REAR OVERHEAD KIT
1	D206-781-371	HAT BIN KIT

5.1.2 D206-781-341/-351/-361/-371 KITS

Qty -341	Qty -351	Qty -361	Qty -371	Part Number	Description
X				D206-781-341	CREW CABIN OVERHEAD KIT
	X			D206-781-351	VERTICAL TUNNEL KIT
		X		D206-781-361	REAR OVERHEAD KIT
			X	D206-781-371	HAT BIN KIT
1				D4116-1	OVERHEAD PANEL W/O DUCT
4				NAS388-6-8P	SCREW
4				NAS391B6P	WASHER
	1			D3828-1	VERTICAL TUNNEL, LOWER LH
	1			D3828-2	VERTICAL TUNNEL, LOWER RH
	1			D3829-1	VERTICAL TUNNEL W/O DUCT, UPPER LH
	1			D3829-2	VERTICAL TUNNEL W/O DUCT, UPPER RH
	1			D3829-3	VERTICAL TUNNEL W/O DUCT, AFT
	1			D3970-3	FIRE EXTINGUISHER COVER W/O DUCT
	4			D3800-1-100-800	LOOP STRIP
	4			D3800-3-100-800	HOOK STRIP
	1			D3989-1-360	SEAL
	6			MS21059L3	NUTPLATE
	12			MS20426AD3-4	RIVET
	6			AN525-10R14	SCREW
		1		D4075-1	REAR OVERHEAD, CENTER
		1		D4076-1	REAR OVERHEAD, LH
		1		D4076-2	REAR OVERHEAD, RH
		14		D4291-1	SPACER
		14		AN525-10R30	SCREW
			1	D3845-1	HAT BIN
			6	D3851-1	DOUBLER
			4	AN525-10R14	SCREW